

FIG. 1

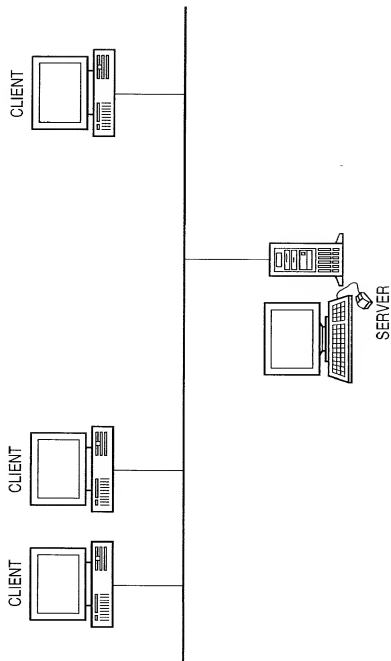


FIG. 2

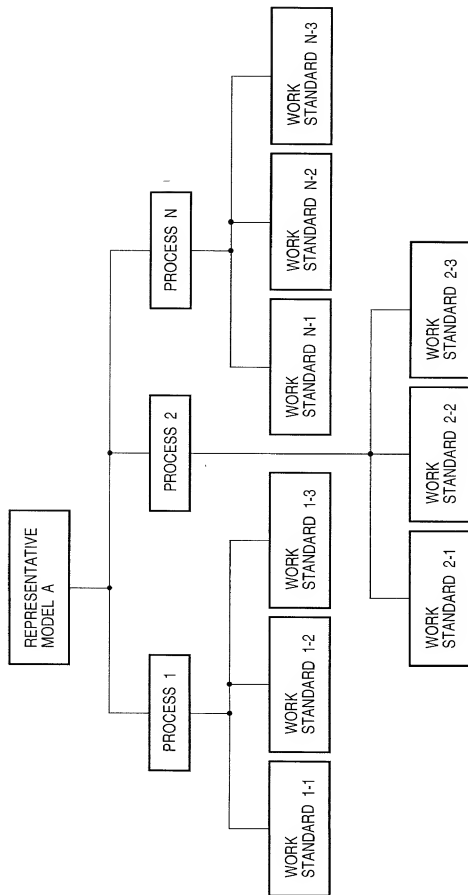


FIG. 4

STRUCTURE OF MASTER FILE

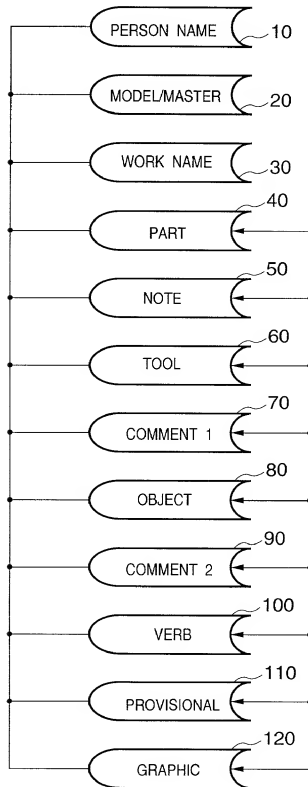


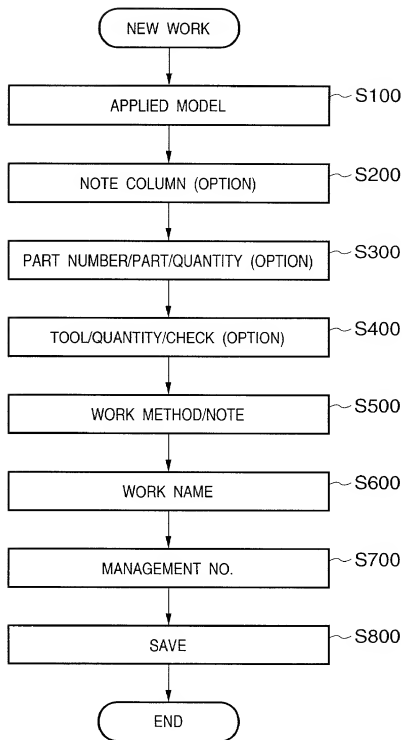
FIG. 5

FIG. 6

SELECTION OF APPLIED MODEL	
LIST OF APPLIED MODELS	
BJC-4200 SYSTEM	
BJC-420J	
BJC-420J (BLACK)	
BJC-4300	
BJC-430J	
BJC-4200LX	
A250 II Q	
BJC-4200	
OK	CANCEL

FIG. 7

WORK STANDARD 01 CREATION					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
APPLIED		BJC-420J BJC-420J(BLACK) BJC-430J				
PART NUMBER		PART NAME		PART NUMBER		QUANTITY
						▲

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FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	-----
000 - 0000 - 002	PART 002		-----
000 - 0000 - 003	PART 003		-----
001 - 0000 - 001	PART 101		-----
001 - 0000 - 002	PART 102	▼	-----
111 - 1111 - 001	PART 001		-----
A01 - 1234 - 001	TEST PART 0001		-----

09753998 010301

FIG. 9

- WORK NAME

GE ____

- CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 10

- WORK NAME

現像(GENZOU) ____

- CANDIDATES

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING
RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING
RAIL RETURN SPRING(AFTER))

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER
IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT) ~を

1103 (COMMENT 2)

1104 (VERB) ~する

00 ※

01

1105a

1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK CANCEL

1108

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FIG. 12

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	1201
	1202
00 ※	1105b
01	

09753993-040304
100000-000000

FIG. 13

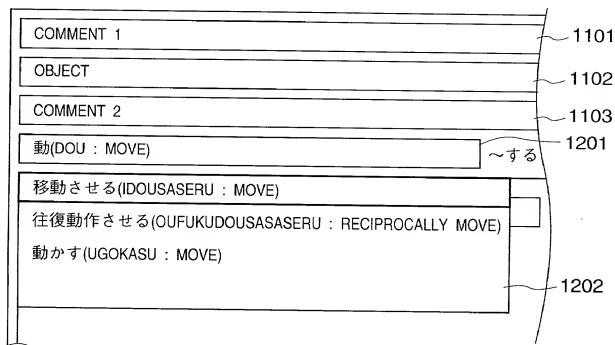


FIG. 14

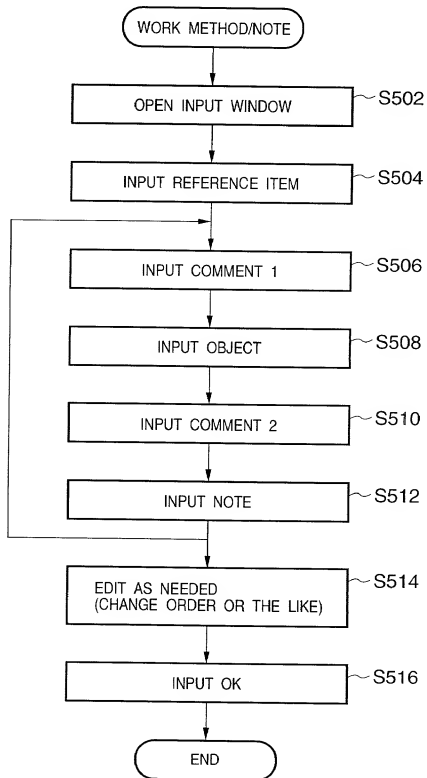


FIG. 15

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY	
NOTE	1601
SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu DONT PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE DONT HOOK PAPER GUIDE u ON SHEET HOLDER BEWARE OF IMITATIONS BEWARE OF IMITATIONS(Color Style Write	
	1602

FIG. 17

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	CUT(I)
02 WIND AV CORD	COPY(C)
03 SET CRG HOLDER	PASTE(P)
04	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

FIG. 19

CONFIRM	～する
00 ※	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

NOTE, STANDARD / REQUIRED QUALITY

FIG. 20

CONFIRM

00 ※

01 WIND AV CORD

02 SET CRG HOLDER

03

NOTE, STANDARD / REQUIRED QUALITY

CUT(I)
COPY(C)
PASTE(P)
ADD(A)
DELETE(D)
UNDO
REVISE(CHANGE)
REVISE(DELETE)

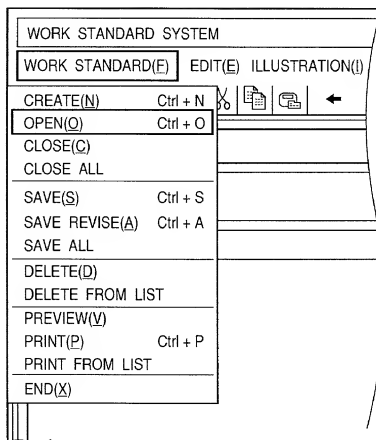
1802

FIG. 21

WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	% [Icon] [Icon] ←
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

09753998-012304

FIG. 22



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FIG. 23

WORK STANDARD SYSTEM				X	
<input checked="" type="radio"/> LATEST REVISION NUMBER <input type="radio"/> ALL					
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION		
SO-04-01(4)-E	01	ASFu取付	1997/09/13		
SO-01-01(3)-E	01	ベース・トレード取付	1997/09/01		
SO-01-03-E	01	ベース・トレード取付	1997/09/01		
SO-01-04-E	01	ベース・トレード取付	1997/09/01		
~~~~~					
SO-06-01-E	01	線処理	1997/09/01		
SO-06-02-E	01	線処理	1997/09/01		
SO-06-03-E	01	線処理	1997/09/01		
SO-07-01(2)-E	01	レールグリス塗布	1997/09/01		
SO-08-01-E	01	レール取付	1997/09/01		
~~~~~					
			OK		CANCEL

2301

FIG. 24



SYSTEM		
EDIT(E)	ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		<div>VIEW(V)</div> <div>EDIT(E)</div> <div>PowerPoint</div> <div>✓ Canvas</div>
01 CREATE		<div>←</div> <div>→</div>

FIG. 26

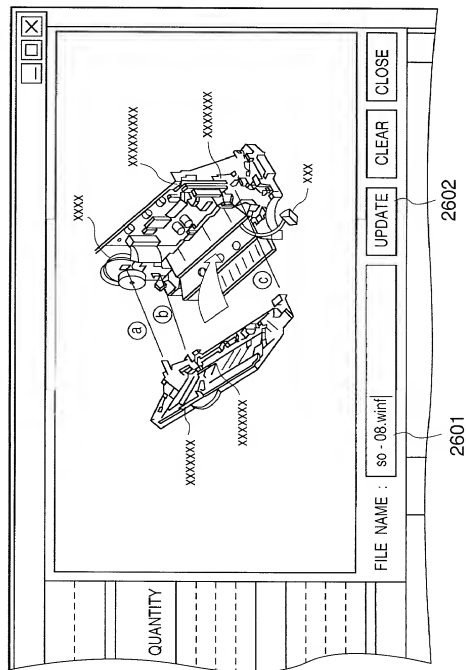


FIG. 27

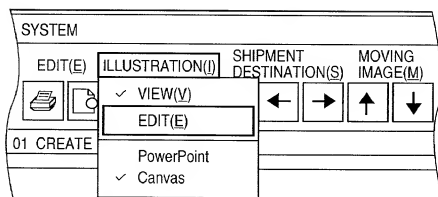


FIG. 28

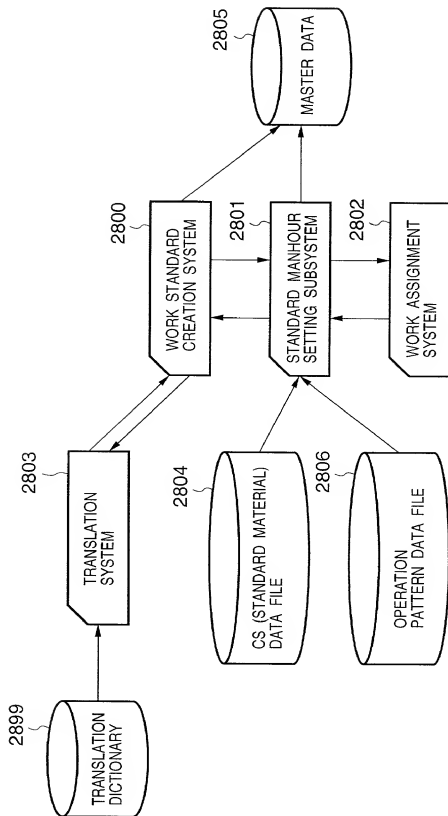


FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA

☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

3001 3002 3003 3004 3000

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

TOTAL ☐ ASSEMBLY ☒ UNIT

DISPLAY DATA

ALL ☒ UNTRANSLATED ☐ UNCHECKED ☐

DISPLAY LANGUAGE

JAPANESE ☐ ENGLISH ☒

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION	CHECK
PT - 010 - 010	01	クリーナウ取付	X	X
PT - 010 - 020	01	クリーナウ取付	X	X
PT - 010 - 030	01	クリーナウ取付	X	X
PT - 070 - 030	01	切換アーム Assy組立	X	X
PT - 080 - 010	01	伝達ローラ取付	X	X
PT - 090 - 010	01	伝達ローラ取付	X	X
PT - 100 - 010	01	紙押え取付	X	X

3006 3007 3008 3005

SELECT ALL CANCEL SELECT VIEW TRANSLATE TRANSLATE ALL CLOSE

X

WORK PROCEDURE

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレードレバーネをブレードレバーの ① 部に引っ掛ける

01 ブレードレバーネをブレードレバーの ① 部に引っ掛ける

02 ブレードレバーを矢印 ② 方向にスライドさせ引っ掛かり無くバネ力で戻ることを確認する

03 ブレードレバー軸先端がブレード軸先端まで圧入されていることを確認する

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

01 The blade lever spring hooks to ① of the blade lever.

02 Side the blade lever in the direction of arrow ② and there is no catch and n....

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed...

TRANSLATE

OK

CANCEL

3200

3201

3202

3203

3204

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)				[-] [X]	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S)	POW(W)		
WORK STANDARD PN-030-020 01 Ne		PLAY(P)	X2056) A252 PLATEN UNIT	[-] [X]	
Model QG5-1317		NEW(N)			
		DRIVE(D)			

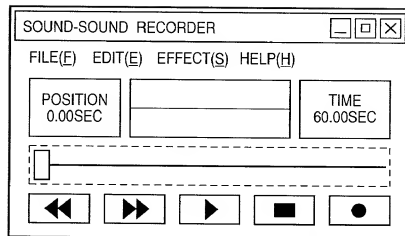
FIG. 34

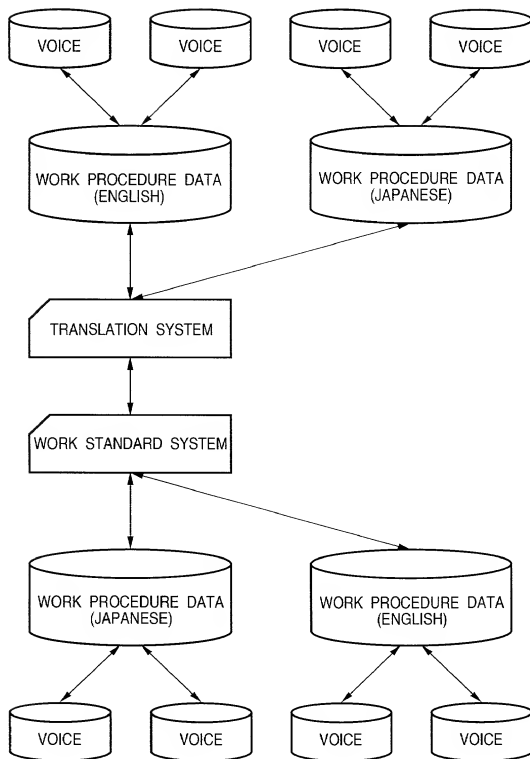
FIG. 35

FIG. 36

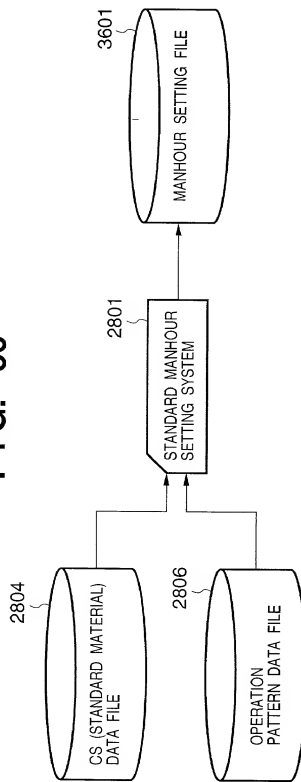


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

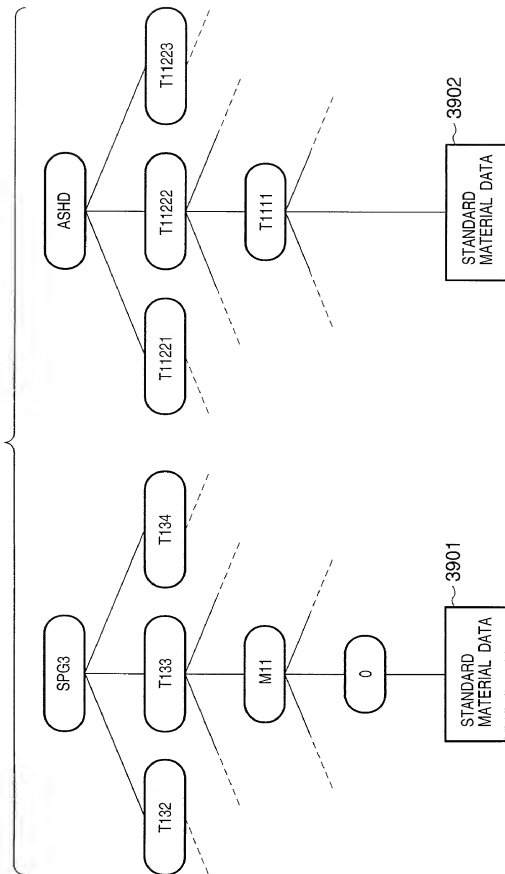


FIG. 40

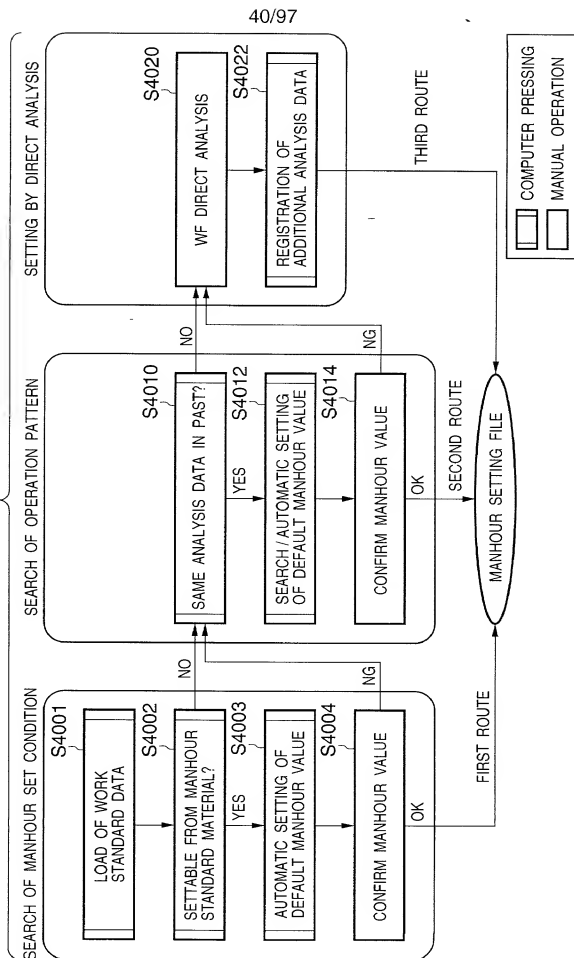


FIG. 41

3601

EDITING OF ELEMENT WORK

FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)

UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT

No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION
1	負荷ハネを負荷ハネ取付治具に組込む (SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1		
2	治具のSWをONにする (TURN ON SW OF TREATMENT DEVICE)	1	1		
3	分離ロー軸を負荷ハネ取付治具に取込む (SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1		
4	治具のSWをOFFにする (TURN OFF SW OF TREATMENT DEVICE)	1	1		
5	分離ロー軸を治具より外す (DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1		



DATA LOAD

● ELEMENT WORK NAME

No.	COMMENT 1	OBJECT	COMMENT 2	VERB
1		負荷ハネを	負荷ハネ取付治具に	組込む
2	治具の	SWを		ONする
3		分離ロー軸を	負荷ハネ取付治具に	組込む
4	治具の	SWを		OFFにする
5		分離ロー軸を	治具より	外す

[illegible]

SEARCH KEYWORD(KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	*ハネを	*に	組込む	SPG3 T133 / M11 / 0	41RU
2	*	*を	*に	組込む	ASHED T11222 / T1111	37RU
3	*	*を	*より	外す	PUMQ T2111 / T111111	16RU
4	*	*エリン'を	*	組込む	RIN2 T11211 / SO	76RU
5	*	*コネク'を	*	差し込む	CONN T11211 / SO	41RU
6	*	*	*	増し締めする	SCR6 M211 / 1	23RU

[illegible]

MATCH

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	治具の	SWを		ONする	/GET:-50E/M:-10E	8RU
2	治具の	SWを		OFFする	/GET:-50E/M:-10E	8RU
3		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
4		CRGトアを		閉める	/GET:-50E/M:-50E	10RU
5		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
6		電源コートを		抜く	/GET:-50Egr2/M:-10E	16RU
7		測定用電源コートを		抜く	/GET:-50Egr2/M:-10E	16RU

0307-4652/95/0005-0000\$05.00/0

FIG. 45

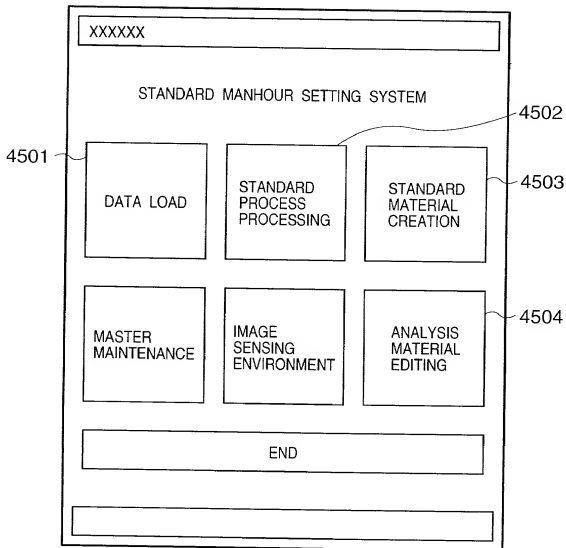


FIG. 46

Figure 1 is a schematic diagram of a graphical user interface (GUI) for a data entry application. The GUI is enclosed in a main window 4601. At the top left is a title bar 4609 containing the text "XXXXXXXX" and three control buttons (minimize, maximize, close) 4610. Below the title bar is a menu bar 4612 with an "OK" button. The main area contains a form with several fields: a radio button labeled "ALL O DESIGNATE : 1" next to a dropdown menu showing "1"; a "PRODUCT NUMBER:" label next to an empty text box; a "NAME:" label next to an empty text box; a "WORK STANDARD" label next to a dropdown menu showing "1"; a "PRODUCT SYMBOL" label next to a dropdown menu showing "XX"; a "PREVIOUS LOAD DATE" label next to a dropdown menu showing "XXX". Below these fields is a table with four columns: "PRODUCT NUMBER", "WORK STANDARD", "PRODUCT SYMBOL", and "PREVIOUS LOAD DATE". The table contains three rows of data: "0 - CLOCK", "XXXXXX", "BL - OLD"; "xyz - test", "test - 01", "test - AMI"; and "test - 01", "test - AMI", "test - AMI". To the right of the table is a "SELECT" button. At the bottom right is a "CANCEL" button. The entire GUI is labeled with reference numerals 4601, 4609, 4610, 4612, 4605, 4604, 4603, 4602, and 4611.

FIG. 47

[illegible]

FIG. 48

100010-86657-00

LOAD OF DATA

COMPONENT DESIGNATION

☐ ALL

☒ DESIGNATE COMPONENT

CH

AUTOMATIC MANHOUR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

EXECUTE

CANCEL

4800

4801

4802

4803

4804

4805

4806

FIG. 49

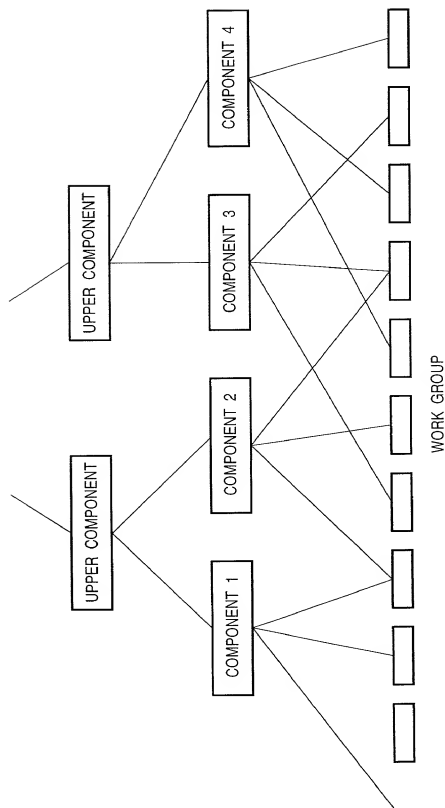


FIG. 50

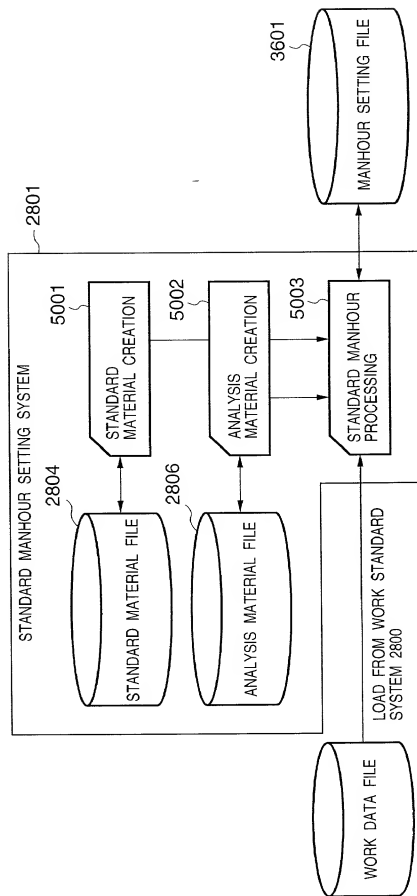
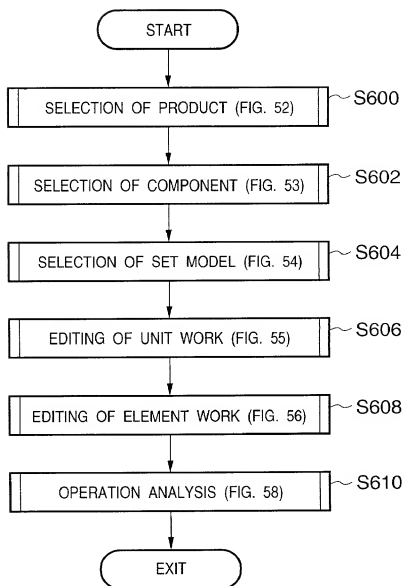


FIG. 51









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FIG. 52

SELECTION OF PRODUCT		FILE(E) EDIT(E)																							
<table border="1"> <thead> <tr> <th>PRODUCT SYMBOL</th> <th>NAME</th> <th>PREVIOUS UPDATE DATE</th> </tr> </thead> <tbody> <tr> <td>BJ - 970909</td> <td>XXXXX</td> <td>1997/09/22 10:17:30</td> </tr> <tr> <td>BJ - STAND</td> <td></td> <td>1997/09/12 15:09:09</td> </tr> <tr> <td>BJ - test</td> <td>TEST 01 Standard</td> <td>1997/09/18 10:38:14</td> </tr> <tr> <td>BJ250</td> <td>250 TESTS</td> <td>1997/09/17 17:58:59</td> </tr> <tr> <td>ST01</td> <td>STAND PRODUCT</td> <td>1997/09/12 16:02:34</td> </tr> <tr> <td>STAND01</td> <td></td> <td>1997/09/19 15:46:04</td> </tr> </tbody> </table>		PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE	BJ - 970909	XXXXX	1997/09/22 10:17:30	BJ - STAND		1997/09/12 15:09:09	BJ - test	TEST 01 Standard	1997/09/18 10:38:14	BJ250	250 TESTS	1997/09/17 17:58:59	ST01	STAND PRODUCT	1997/09/12 16:02:34	STAND01		1997/09/19 15:46:04			
PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE																							
BJ - 970909	XXXXX	1997/09/22 10:17:30																							
BJ - STAND		1997/09/12 15:09:09																							
BJ - test	TEST 01 Standard	1997/09/18 10:38:14																							
BJ250	250 TESTS	1997/09/17 17:58:59																							
ST01	STAND PRODUCT	1997/09/12 16:02:34																							
STAND01		1997/09/19 15:46:04																							
<div>SET MANHOUR</div>		<div>EXTRACT DATA</div>		<div>CREATE HOST TRANSFER</div>																					
		<div>ANALYZE DATA</div>		<div>END</div>																					

5201

FIG. 53

SELECTION OF COMPONENT			
FILE(E) EDIT(E)			
<div>         </div>			
PRODUCT SYMBOL : BJ - 4200		NAME : BJ - 4200	
COMPONENT SYMBOL	NAME	PREVIOUS UPDATE DATE	
<div> <div>▲ BK</div> <div>CH</div> <div>KO</div> </div>	<div>XXXX</div> <div>CHECK PROCESS</div> <div>PACKAGE</div>	<div>1997/09/22 11:09:59</div> <div>1997/09/12 11:09:59</div> <div>1997/09/18 11:21:07</div>	
<div> <div>NEXT</div> <div>DOWNLOAD</div> <div>UPLOAD</div> <div>BACK UP</div> <div>LIST</div> <div>CANCEL ACCESS FLAG</div> <div>END</div> </div>			

5301

FIG. 54

SELECTION OF MODEL			
FILE(E) EDIT(E) VIEW(V)			
PRODUCT NUMBER : BJ-970909		NAME : 97-09-09 LOAD	
COMPONENT SYMBOL : CH		NAME :	

SET MODEL SYMBOL	QUANTITY	NAME	PREVIOUS PUBLICATION DATE
▶ A250 IIQ			
BJC - 4200LX			
BJC - 4200 SYSTEM			
BJC - 420J			
BJC - 420J(BLACK)			
BJC - 4300		X X X X X	1997/09/09 10:46:33
BJC - 430J			

NEXT	REGISTER PUBLICATION	LOOK PUBLICATION	DISPLAY SAME MODEL	END
------	----------------------	------------------	--------------------	-----

FIG. 55

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SELECTION OF MODEL											
FILE(E) EDIT(E) VIEW(V)											
<div> <div> <div>FILE(E)</div> <div>EDIT(E)</div> <div>VIEW(V)</div> </div> <div> <div>FILE(E)</div> <div>EDIT(E)</div> <div>VIEW(V)</div> </div> <div> <div>FILE(E)</div> <div>EDIT(E)</div> <div>VIEW(V)</div> </div> </div>											
PRODUCT SYMBOL : BJ - 970909		NAME : 097 - 09 - 09 LOAD		SET MODEL SYMBOL : BJC - 4300		LATEST REVISION NUMBER		UPDATE DISPLAY			
COMPONENT SYMBOL : ON		NAME :		NAME : xxxxxx							
S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY				
N ^o 3	CH-01-01	1	電気チェック	0	0	0	0	1			
N ^o 4	CH-01-02(1)	1	電気チェック	0	0	0	0	1			
N ^o 5	CH-01-02(2)	1	電気チェック	0	0	0	0	1			
N ^o 6	CH-01-03	1	電気チェック	0	0	0	0	1			
N ^o 7	CH-01-04	1	電気チェック	0	0	0	0	1			
N ^o 23	CH-07-02(1)	1	フロントカバ-u取付	0	0	0	0	1			
N ^o 24	CH-07-02(2)	1	フロントカバ-u取付	0	0	0	0	1			
N ^o 25	CH-07-01(3)	1	フロントカバ-u取付	0	0	0	0	1			
N ^o 26	CH-07-01(4)	1	フロントカバ-u取付	0	0	0	0	1			
No.	FORMAL MANAGEMENT NO.	UNIT WORK NAME		MANHOUR	USE	FREQUENCY	1	2	3	4	5
3	CH-01-01	ELECTRICAL CHECK		0	0	0	1				
<div> <div> <div>CHANGE</div> <div>INSERT</div> <div>ADD</div> </div> <div>OK</div> </div>											

5501 5507 5506 5502 5503 5504 5505

FIG. 56

XXXXXX									
<div> <div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div> </div>		FORMAL MANAGEMENT NO. PU-03-01 UNIT WORK NAME: MOTOR ATTACHMENT TOTAL MANHOUR: <input type="text" value="0"/> NEXT UNIT WORK							
		ELEMENT WORK NAME		REVISION	MANHOUR	USE	CS	SET CONDITION	
▶ 1		LFE-タのケーブルと反対側の軸にタプルキア		1	0	0			
*									
<div> <div>COMMENT 1 :</div> <div>LFE-タのケーブルと反対側の軸に</div> <div>OBJECT :</div> <div>タプルキアを</div> <div>COMMENT 2 :</div> <div>キア径の小さい方から</div> <div>VERB :</div> <div>取付ける</div> <div>設定</div> </div>									

5604

5605

5603

5602

5601

FIG. 57

FILE(F) EDIT(E) VIEW(V)

PRODUCT GENRE :

	TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MAN-HOUR USE	FREQUENCY COUNT	SET DATE
▲	アークアップ:	本体を	矢印1の様に	入れる	入れる	-50/G1/N1>6/3	15	0 1 1 0	97/09/09 9:52
	アークアップ:	本体を	矢印1の様に	入れる	入れる	-50/E/02/N1>6	11	0 1 1 0	97/09/08 9:53
	アークアップ:	本体を	矢印1の様に	入れる	入れる	-50/G1/N1>6/3	15	0 1 1 0	97/09/09 9:55
		要素作業01	本体を	矢印1の様に	動詞	入れる	-50/G1/N1>6/3	15	0 1 1 0
モータ組立:	アークアップ:	本体を	矢印1の様に	入れる	入れる	-50/G1/N1>6/3	15	0 1 1 0	97/09/10 19:09
	キャップ・ロウ	キャップ・ロウ	塗布する	塗布する	塗布する	Time100/Rate100	100	1 1 1 1	97/09/10 19:16
	アリンダジャー	アリンダジャー	入れ、セトする	入れ、セトする	M211/1/10	50	1 1 1 1	1	97/09/11 17:00
	アリンダジャー	アリンダジャー	裏面にする	裏面にする	T1221/M2311/0/0	12	0 1 1 0	1	97/09/11 17:34
	1		1		T2221/M1211/0/1	24	0 1 1 0	1	97/09/11 17:20
	2		2		T1221/M2311/0/0	12	0 1 1 0	1	97/09/11 17:24
	アリンダジャー	アリンダジャー	PRG「ト」取得する	PRG「ト」取得する	セトする	セトする	15	0 1 1 0	97/09/12 11:24
	dgfrldfias	dgfrldfias	ifcadsifcadsfad	ifcadsifcadsfad	ifcadsifcadsfad	*	16	0 1 1 0	97/09/12 12:10
	dgfrldfias	dgfrldfias	ifcadsifcadsfad	ifcadsifcadsfad	ifcadsifcadsfad	T2121/M1111/0/1	13	0 1 1 0	97/09/12 12:10
	dgfrldfias	dgfrldfias	ifcadsifcadsfad	ifcadsifcadsfad	ifcadsifcadsfad	*	16	0 1 1 0	97/09/12 13:39
アリンダジャー	アリンダジャー	アリンダジャー	PRG「ト」取得する	PRG「ト」取得する	セトする	セトする	15	0 1 1 0	97/09/12 14:00
	アリンダジャー	アリンダジャー	PRG「ト」取得する	PRG「ト」取得する	セトする	セトする	15	0 1 1 0	97/09/12 14:00
	アリンダジャー	アリンダジャー	PRG「ト」取得する	PRG「ト」取得する	セトする	セトする	100	1 1 1 0	97/09/12 14:04

FIG. 58

OPERATION ANALYSIS				5801	5802	5803	5804	5805	
<div> </div>									
1 SET MAIN BODY TO PREDETERMINED POSITION				TOTAL SIMO VALUE : 0		TOTAL MANHOUR VALUE : 15		NEXT ELEMENT WORK	
NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MANHOUR	USE	REMARKS			
▲ 1	XXXXXX	PU	-60/Grt/NL>6+3	15	0				
*									

FIG. 59

☐ 1. PU

☐ 6. DSY

☐ 11. PU

☐ 16. DSY

☐ 2. GET

☐ 7. R

☐ 12. GET

☐ 17. R

☐ 3. M

☐ 8. UMAC

☐ 13. M

☐ 4. MA

☐ 9. MP

☐ 14. MA

☐ 5. ASY

☐ 10. BODY

☐ 15. ASY

☐ SIMO

SELECT

CANCEL

5902

5901

FIG. 60

XXXXXX					
PU		PICK UP		MANUAL	
1 :	MOVING DISTANCE	1	2	3	6
		-10cm	+10cm	> 50cm	
2 :	GRIP TYPE	Qr-3	Qr-2		
3 :	PRE-POSITIONING	NO	YES		
4 :	MAIN SIZE	-10mm	-6mm		
5 :	WEIGHT	<3Kg	>3Kg		
6 :					
SET		CANCEL		SET VALUE	FORMULA
6001		6002		6003	

FIG. 61

FORMULA

TURN CHANGE DIRECTION OF BODY MANUAL

FORMULA : 10 * m

VARIABLE

m :

n :

p :

q :

r :

s :

VARIABLE NAME

THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION

VALUE

UNIT

COUNT

SET

CANCEL

SET VALUE

FIG. 62

The figure shows a graphical user interface window titled "INQUIRY OF LOG". The window contains several input fields and two buttons. The labels and their corresponding values or states are as follows:

- VARIATION AMOUNT :** 10
- USE :** 0
- REASON CODE :** 1
- CHANGE REASON :** SET (with a dropdown arrow)
- Buttons:** OK and Clear

Reference numerals point to specific elements: 6201 points to the title bar, 6202 points to the VARIATION AMOUNT field, 6203 points to the USE field, 6204 points to the CHANGE REASON field, 6205 points to the OK button, and 6206 points to the Clear button.

FIG. 63

6301

6302

CORRECTION OF CHANGE LOG

DATE

1997 09 22 ○ = ○ FROM
○ BEFORE ○ ~

SEARCH

NO.	UNIT	WORK NAME	CODE	CHANGE REASON	NEW MANHOUR	(NEW) MANUAL	(NEW) USE	PREVIOUS (PREVIOUS) MANHOUR	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	10	0	0	0	1997/09/22 14.30.00

REASON CODE

1

CHANGE REASON

SET



OK

CIR

END

FIG. 64

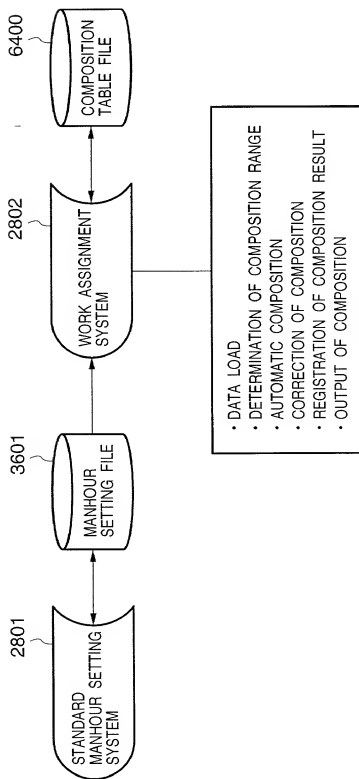


FIG. 65

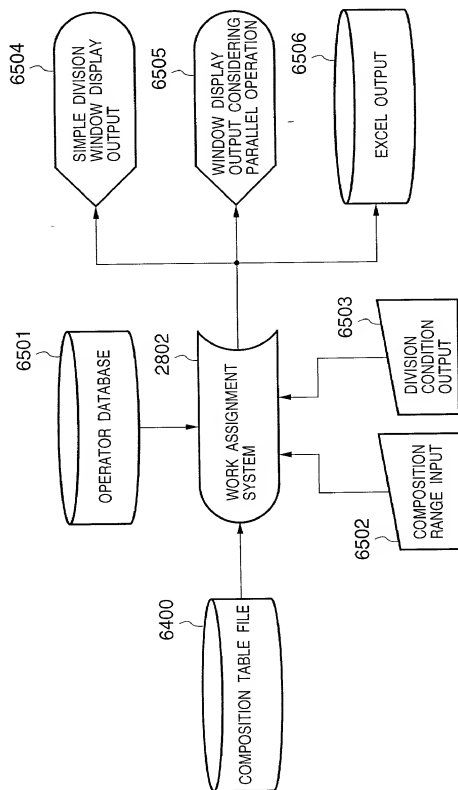


FIG. 66

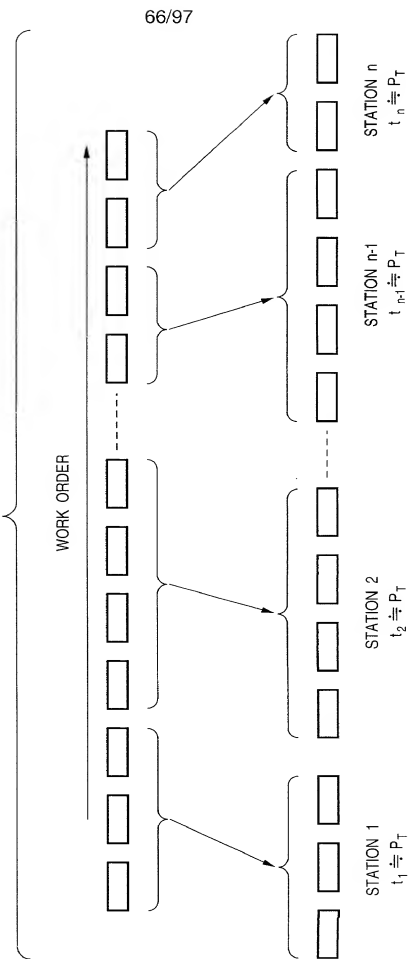


FIG. 67

		▶	◀▶
FILE(F) EDIT(E) INPUT(I) TOOL(O)			

MODEL

GP55

UNIT

STANDARD NO.	WORK NAME	MAN/ HOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

⋮

⎵

SIMPLE DIVISION
PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

		▼	▲
FILE(F) EDIT(E)		◆	
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
⋮			

FIG. 69

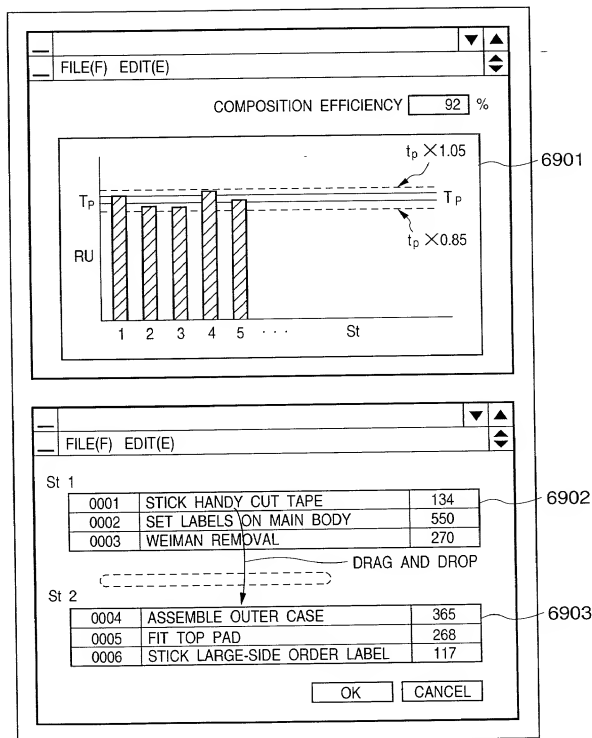
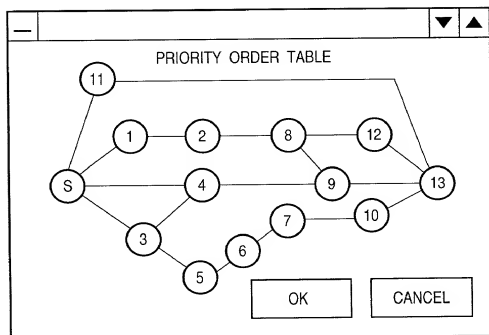


FIG. 70

PARALLEL DIVISION

PLAN 2		PLAN 1	
St 1		St 1	
1		1	STICK HANDY CUT TAPE 99
2		2	SET LABELS ON MAIN BODY 78
8		3	WEIMAN REMOVAL 134
St 2		St 2	
3		4	ASSEMBLE OUTER CASE 732
4		5	FIT TOP PAD 268
5		6	STICK LARGE-SIDE ORDER LABEL 117
			⋮

FIG. 72

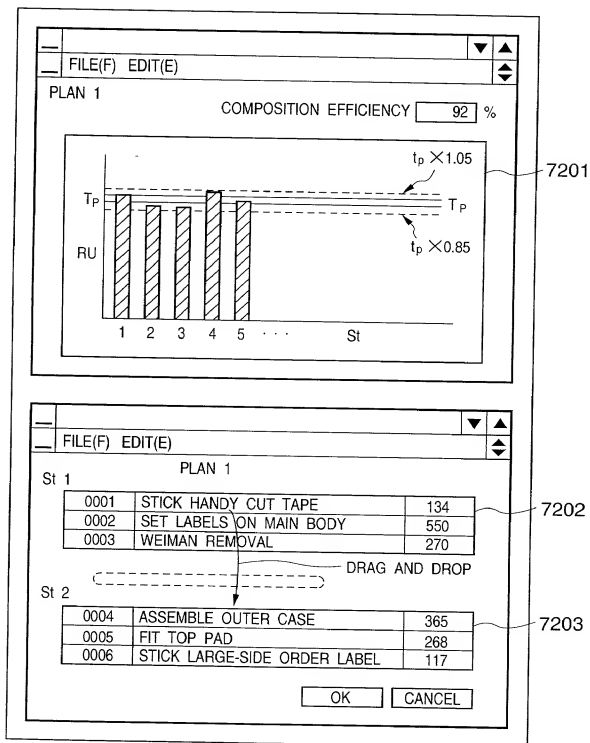


FIG. 73

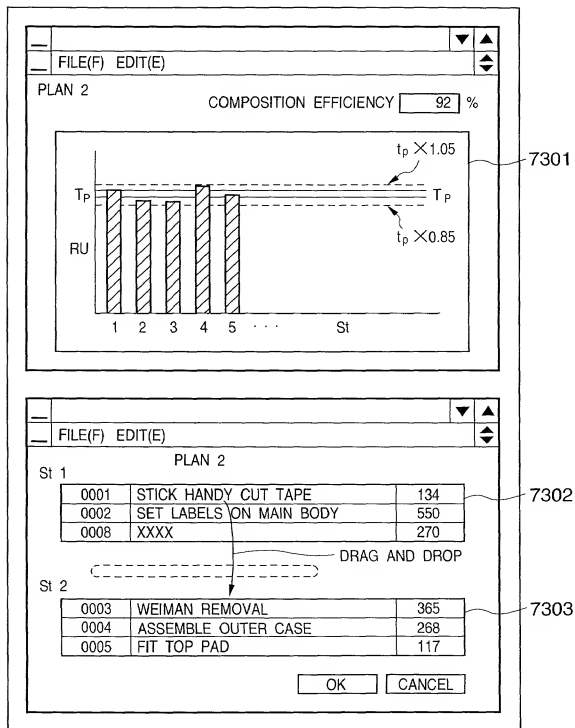


FIG. 74

7401

7402

7403

7404

7405

7406

7407

7409

74/97

7408

LOAD OF NEWLY COMPOSED DATA (MANHOURL)

GENRE

REPRESENTATIVE MODEL

TARGET MODEL

COMPONENT

COMPONENT SYMBOL	COMPONENT NAME	ORDER

BJ
FAX
LBP
NP
STAND

OK

CANCEL

FIG. 75

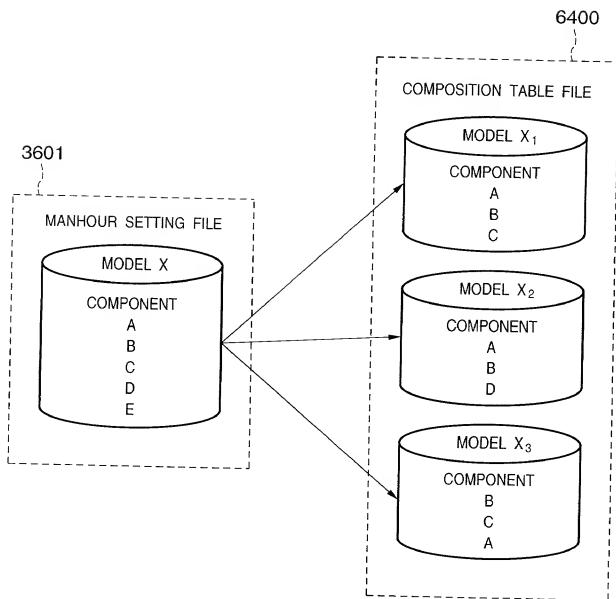


FIG. 76

7601

7602

7603

7604

7606

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

TARGET MODEL	NAME	REVISION NUMBER	SAVE DATE
f12-0010.csv	テストデータ(元)	1	97/09/19 12:00:34
f12-0010.csv	テスト	0	97/09/19 13:27:17
BJC-4300	0	0	97/09/19 14:10:14
BJC-4300	0	0	97/09/19 14:10:32
BJC-4300	BJC-4300Aライン編成	1	97/09/19 15:41:14
BJC-4300	BJC-4300Aライン編成	03	97/10/13 17:54:57
BJC-4300	BJC-4300Aライン編成	00	97/09/20 14:06:36
f12-0010.csv	f12-0010Aライン編成	05	97/09/24 17:11:53

SELECT WINDOW

☐ COMPOSITION DATA INPUT WINDOW

☐ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

FIG. 78

09753998.010301

7801

7802

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

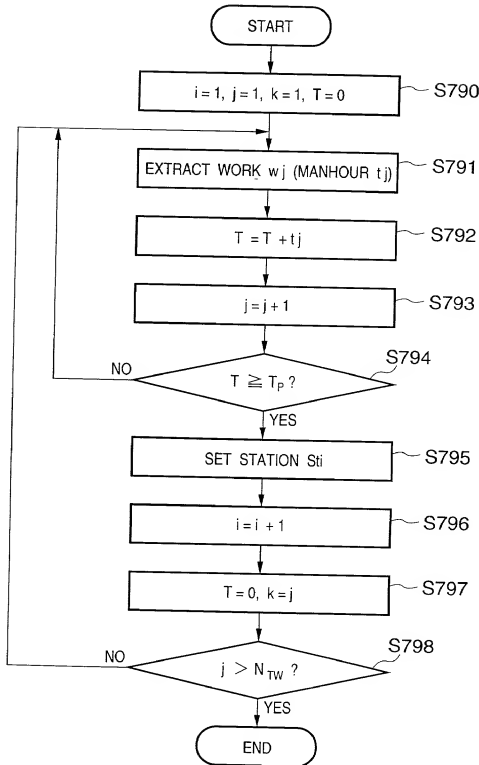
UNIT WORK NAME :

PROVISIONAL MANHOUR : (RU)

REMARKS :

OK CANCEL

FIG. 79



FILE(F) EDIT(E) VIEW(V) TOOL(T)

FIG. 81

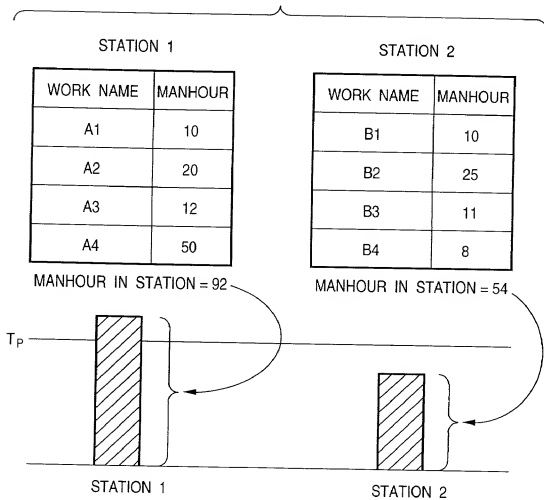


FIG. 82

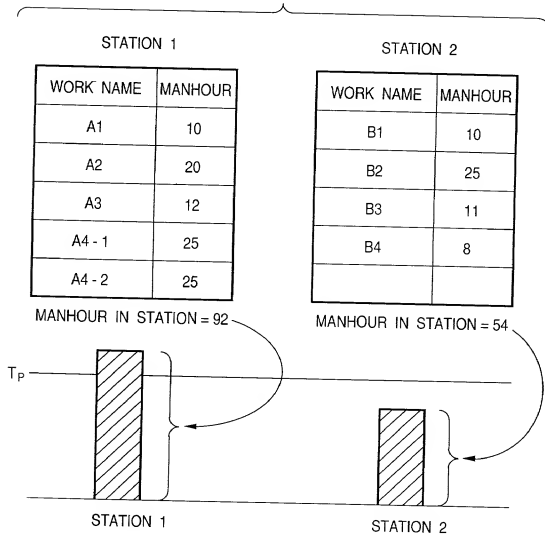


FIG. 83

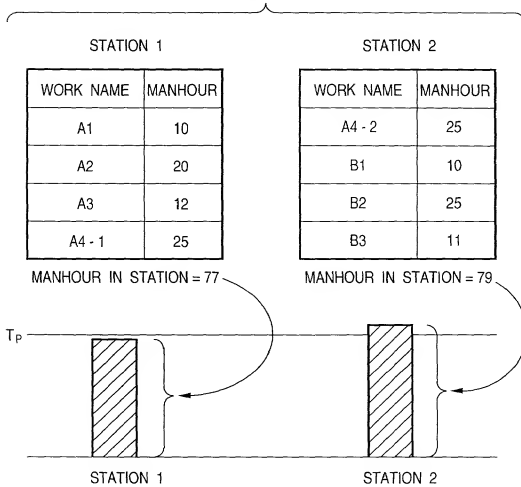


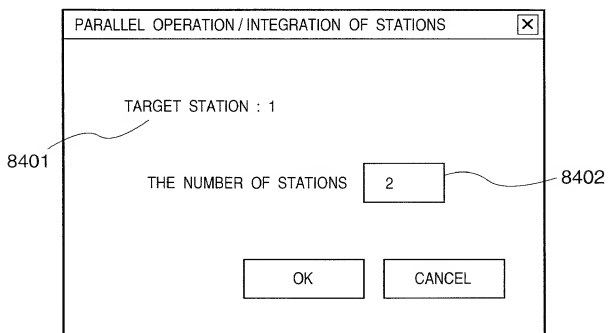
FIG. 84

FIG. 85

FILE(F) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1 OPERATOR 2 OPERATOR 3 OPERATOR 4 OPERATOR 5

S1 S2 S3 S4 S5

WORK NAME	PROV. MANHOUR	WF SIGNAL	MA CHINE	MANHOUR
UNIT WORK 34	10	No 01		No 22
NAME 1				
UNIT WORK 255	46	No 02		No 23
NAME 2				
UNIT WORK 32	26	No 06		No 24
NAME 3				
UNIT WORK 52	0	No 07		No 25
NAME 4				
UNIT WORK 52	0	No 08		No 26
NAME 5				
UNIT WORK 52	36	No 09		No 27
NAME 6				
UNIT WORK 52	0	No 10		No 28
NAME 7				
UNIT WORK 52	0	No 11		No 29
NAME 8				
UNIT WORK 52	0	No 12		No 30
NAME 9				
UNIT WORK 52	0	No 13		No 31
NAME 10				
UNIT WORK 52	0	No 14		No 32
NAME 11				
UNIT WORK 52	0	No 15		No 33
NAME 12				
UNIT WORK 52	0	No 16		No 34
NAME 13				
UNIT WORK 52	0	No 17		No 35
NAME 14				
UNIT WORK 52	0	No 18		No 36
NAME 15				
UNIT WORK 30	40	No 19		No 37
NAME 16				
UNIT WORK 303	131	No 20		No 38
NAME 17				
UNIT WORK 84	26	No 21		No 39
NAME 18				
UNIT WORK 120	20	No 22		No 40
NAME 19				
UNIT WORK 310	66	No 23		No 41
NAME 20				
UNIT WORK 168	26	No 24		No 42
NAME 21				
UNIT WORK 146	71	No 25		No 43
NAME 22				
UNIT WORK 61	0	No 26		No 44
NAME 23				
UNIT WORK 51	10	No 27		No 45
NAME 24				
UNIT WORK 0	0	No 28		No 46
NAME 25				
UNIT WORK 0	0	No 29		No 47
NAME 26				
UNIT WORK 0	0	No 30		No 48
NAME 27				
UNIT WORK 0	0	No 31		No 49
NAME 28				
UNIT WORK 0	0	No 32		No 50
NAME 29				
UNIT WORK 0	0	No 33		No 51
NAME 30				
UNIT WORK 0	0	No 34		No 52
NAME 31				
UNIT WORK 0	0	No 35		No 53
NAME 32				
UNIT WORK 0	0	No 36		No 54
NAME 33				
UNIT WORK 0	0	No 37		No 55
NAME 34				
UNIT WORK 0	0	No 38		No 56
NAME 35				
UNIT WORK 0	0	No 39		No 57
NAME 36				
UNIT WORK 0	0	No 40		No 58
NAME 37				
UNIT WORK 0	0	No 41		No 59
NAME 38				
UNIT WORK 0	0	No 42		No 60
NAME 39				
UNIT WORK 0	0	No 43		No 61
NAME 40				
UNIT WORK 0	0	No 44		No 62
NAME 41				
UNIT WORK 0	0	No 45		No 63
NAME 42				
UNIT WORK 0	0	No 46		No 64
NAME 43				
UNIT WORK 0	0	No 47		No 65
NAME 44				
UNIT WORK 0	0	No 48		No 66
NAME 45				
UNIT WORK 0	0	No 49		No 67
NAME 46				
UNIT WORK 0	0	No 50		No 68
NAME 47				
UNIT WORK 0	0	No 51		No 69
NAME 48				
UNIT WORK 0	0	No 52		No 70
NAME 49				
UNIT WORK 0	0	No 53		No 71
NAME 50				
UNIT WORK 0	0	No 54		No 72
NAME 51				
UNIT WORK 0	0	No 55		No 73
NAME 52				
UNIT WORK 0	0	No 56		No 74
NAME 53				
UNIT WORK 0	0	No 57		No 75
NAME 54				
UNIT WORK 0	0	No 58		No 76
NAME 55				
UNIT WORK 0	0	No 59		No 77
NAME 56				
UNIT WORK 0	0	No 60		No 78
NAME 57				
UNIT WORK 0	0	No 61		No 79
NAME 58				
UNIT WORK 0	0	No 62		No 80
NAME 59				
UNIT WORK 0	0	No 63		No 81
NAME 60				
UNIT WORK 0	0	No 64		No 82
NAME 61				
UNIT WORK 0	0	No 65		No 83
NAME 62				
UNIT WORK 0	0	No 66		No 84
NAME 63				
UNIT WORK 0	0	No 67		No 85
NAME 64				
UNIT WORK 0	0	No 68		No 86
NAME 65				
UNIT WORK 0	0	No 69		No 87
NAME 66				
UNIT WORK 0	0	No 70		No 88
NAME 67				
UNIT WORK 0	0	No 71		No 89
NAME 68				
UNIT WORK 0	0	No 72		No 90
NAME 69				
UNIT WORK 0	0	No 73		No 91
NAME 70				
UNIT WORK 0	0	No 74		No 92
NAME 71				
UNIT WORK 0	0	No 75		No 93
NAME 72				
UNIT WORK 0	0	No 76		No 94
NAME 73				
UNIT WORK 0	0	No 77		No 95
NAME 74				
UNIT WORK 0	0	No 78		No 96
NAME 75				
UNIT WORK 0	0	No 79		No 97
NAME 76				
UNIT WORK 0	0	No 80		No 98
NAME 77				
UNIT WORK 0	0	No 81		No 99
NAME 78				
UNIT WORK 0	0	No 82		No 100
NAME 79				
UNIT WORK 0	0	No 83		No 101
NAME 80				
UNIT WORK 0	0	No 84		No 102
NAME 81				
UNIT WORK 0	0	No 85		No 103
NAME 82				
UNIT WORK 0	0	No 86		No 104
NAME 83				
UNIT WORK 0	0	No 87		No 105
NAME 84				
UNIT WORK 0	0	No 88		No 106
NAME 85				
UNIT WORK 0	0	No 89		No 107
NAME 86				
UNIT WORK 0	0	No 90		No 108
NAME 87				
UNIT WORK 0	0	No 91		No 109
NAME 88				
UNIT WORK 0	0	No 92		No 110
NAME 89				
UNIT WORK 0	0	No 93		No 111
NAME 90				
UNIT WORK 0	0	No 94		No 112
NAME 91				
UNIT WORK 0	0	No 95		No 113
NAME 92				
UNIT WORK 0	0	No 96		No 114
NAME 93				
UNIT WORK 0	0	No 97		No 115
NAME 94				
UNIT WORK 0	0	No 98		No 116
NAME 95				
UNIT WORK 0	0	No 99		No 117
NAME 96				
UNIT WORK 0	0	No 100		No 118
NAME 97				
UNIT WORK 0	0	No 101		No 119
NAME 98				
UNIT WORK 0	0	No 102		No 120
NAME 99				
UNIT WORK 0	0	No 103		No 121
NAME 100				
UNIT WORK 0	0	No 104		No 122
NAME 101				
UNIT WORK 0	0	No 105		No 123
NAME 102				
UNIT WORK 0	0	No 106		No 124
NAME 103				
UNIT WORK 0	0	No 107		No 125
NAME 104				
UNIT WORK 0	0	No 108		No 126
NAME 105				
UNIT WORK 0	0	No 109		No 127
NAME 106				
UNIT WORK 0	0	No 110		No 128
NAME 107				
UNIT WORK 0	0	No 111		No 129
NAME 108				
UNIT WORK 0	0	No 112		No 130
NAME 109				
UNIT WORK 0	0	No 113		No 131
NAME 110				
UNIT WORK 0	0	No 114		No 132
NAME 111				
UNIT WORK 0	0	No 115		No 133
NAME 112				
UNIT WORK 0	0	No 116		No 134
NAME 113				
UNIT WORK 0	0	No 117		No 135
NAME 114				
UNIT WORK 0	0	No 118		No 136
NAME 115				
UNIT WORK 0	0	No 119		No 137
NAME 116				
UNIT WORK 0	0	No 120		No 138
NAME 117				
UNIT WORK 0	0	No 121		No 139
NAME 118				
UNIT WORK 0	0	No 122		No 140
NAME 119				
UNIT WORK 0	0	No 123		No 141
NAME 120				
UNIT WORK 0	0	No 124		No 142
NAME 121				
UNIT WORK 0	0	No 125		No 143
NAME 122				
UNIT WORK 0	0	No 126		No 144
NAME 123				
UNIT WORK 0	0	No 127		No 145
NAME 124				
UNIT WORK 0	0	No 128		No 146
NAME 125				
UNIT WORK 0	0	No 129		No 147
NAME 126				
UNIT WORK 0	0	No 130		No 148
NAME 127				
UNIT WORK 0	0	No 131		No 149
NAME 128				
UNIT WORK 0	0	No 132		No 150
NAME 129				
UNIT WORK 0	0	No 133		No 151
NAME 130				
UNIT WORK 0	0	No 134		No 152
NAME 131				
UNIT WORK 0	0	No 135		No 153
NAME 132				
UNIT WORK 0	0	No 136		No 154
NAME 133				
UNIT WORK 0	0	No 137		No 155
NAME 134				
UNIT WORK 0	0	No 138		No 156
NAME 135				
UNIT WORK 0	0	No 139		No 157
NAME 136				
UNIT WORK 0	0	No 140		No 158
NAME 137				
UNIT WORK 0	0	No 141		No 159
NAME 138				
UNIT WORK 0	0	No 142		No 160
NAME 139				
UNIT WORK 0	0	No 143		No 161
NAME 140				
UNIT WORK 0	0	No 144		No 162
NAME 141				
UNIT WORK 0	0	No 145		No 163
NAME 142				

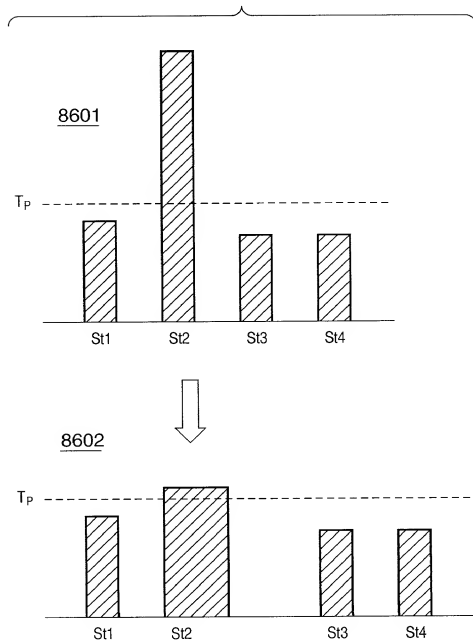
FIG. 86

FIG. 87

A diagram of a 'USER REGISTRATION' dialog box. The dialog box has a title bar with a close button (X). Inside, there are five input fields and two buttons. The fields are labeled on the left: 'NAME CODE :', 'NAME :', 'POSITION :', 'PASSWORD :', and 'AUTHORITY :'. The 'NAME' field is split into two boxes containing '田中' and '一郎'. The 'POSITION' field is a single box containing 'kumitate' with a dropdown arrow on the right. The 'PASSWORD' and 'AUTHORITY' fields are single boxes. Below the fields are two buttons labeled 'OK' and 'CANCEL'. On the right side of the dialog box, there are five reference numbers (8701, 8702, 8703, 8704, 8705) with wavy lines pointing to the input boxes for 'NAME CODE', 'NAME' (both parts), 'POSITION', 'PASSWORD', and 'AUTHORITY' respectively.

USER REGISTRATION

NAME CODE : 12345 8701

NAME : 田中 一郎 8702

POSITION : kumitate 8703

PASSWORD : 12345 8704

AUTHORITY : 8705

OK CANCEL

FIG. 88

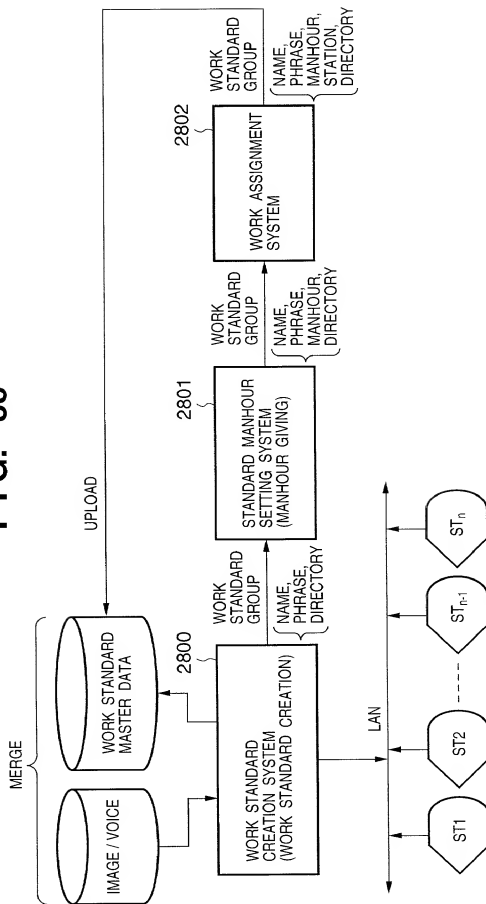


FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

FIG. 90

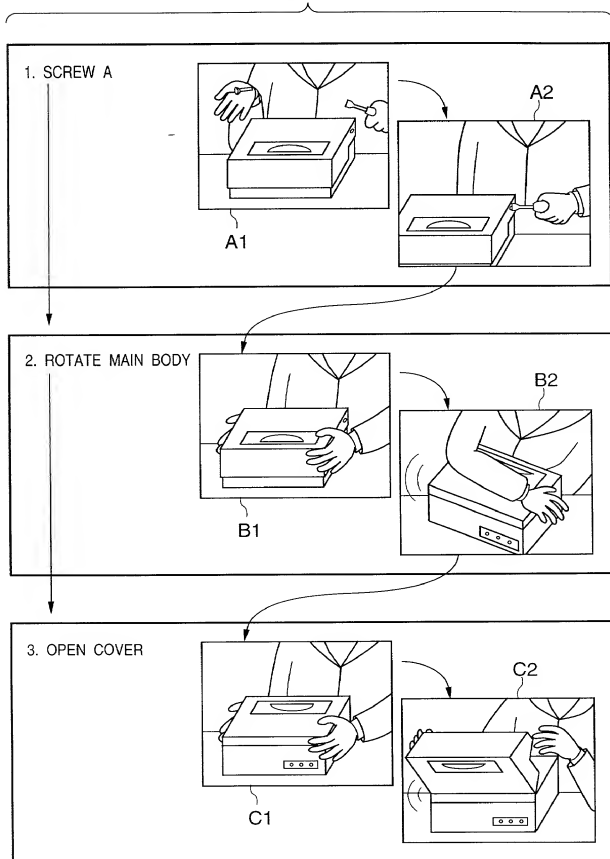


FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

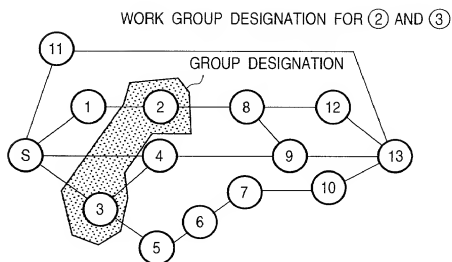
FIG. 92

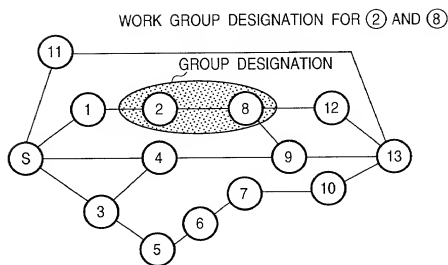
FIG. 93

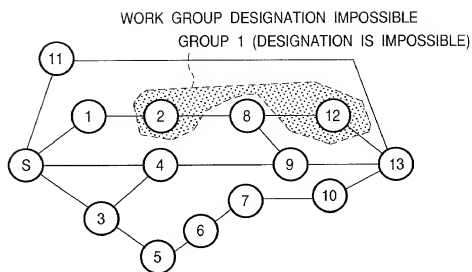
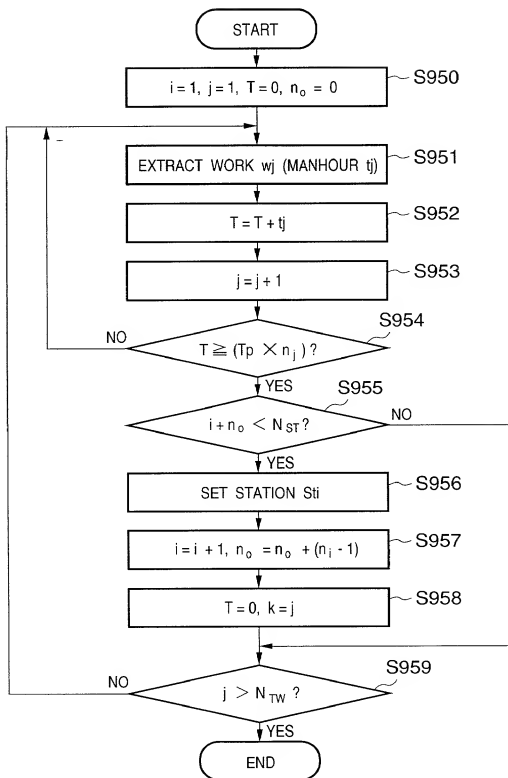
FIG. 94

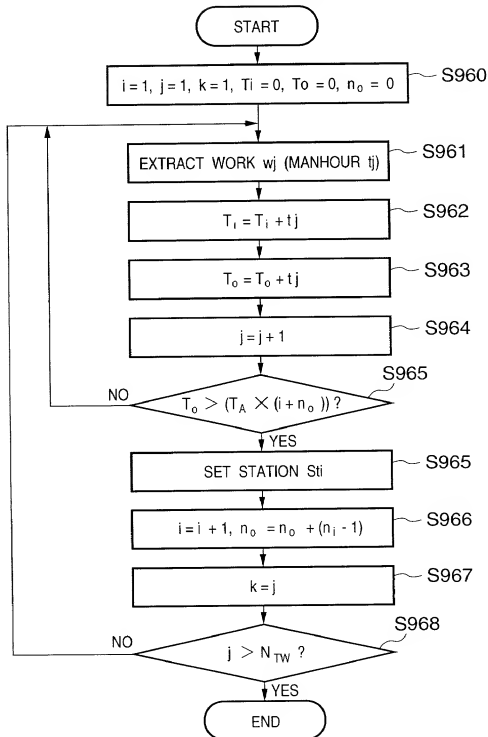
FIG. 95



N_{ST} : THE NUMBER OF STATIONS
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

96/97

FIG. 96



N_{ST} : THE NUMBER OF STATIONS

T_i : i STATION MANHOUR

T_A : STATION MANHOUR AVERAGE VALUE

$T_A = W_F / N_{ST}$

T_o : TOTAL ACCUMULATED MANHOUR

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL
SUM NUMBER

09753998-010301

FIG. 97

FILE(E) EDIT(E) VIEW(D) TOOL(I)

OPERATOR 1 OPERATOR 2 OPERATOR 3 OPERATOR 4 OPERATOR 5 OPERATOR 6

S1 S2 S3 S4 S5

WORK NAME	WF	PROV. SIGNAL	MAN-CHINE	UAL
START	0	0	No	
UNIT WORK 34	10	No 01		
UNIT WORK 255	46	No 02		
NAME 2				
UNIT WORK 92	25	No 05		
NAME 6				
UNIT WORK 52	0	No 07		
NAME 12				
UNIT WORK 88	0	No 14		
NAME 15				
UNIT WORK 48	18	No 15		
NAME 14				
UNIT WORK 546	15	No 16		
NAME 13				
UNIT WORK 59	20	No 17		
NAME 13				
TOTAL 555 (RU) PF 83.5% PARALLEL STATIONS PF 117.3%				

WORK NAME	WF	PROV. SIGNAL	MAN-CHINE	UAL
UNIT WORK 156	0	No 03		
NAME 4				
UNIT WORK 34	0	No 04		
UNIT WORK 138	23	No 06		
NAME 10				
UNIT WORK 71	48	No 10		
NAME 10				
UNIT WORK 138	30	No 11		
NAME 12				
UNIT WORK 97	20	No 12		
NAME 12				
UNIT WORK 88	0	No 14		
NAME 15				
UNIT WORK 48	18	No 15		
NAME 14				
UNIT WORK 546	15	No 16		
NAME 13				
UNIT WORK 59	20	No 17		
NAME 13				
TOTAL 572 (RU) PF 86.7%				

WORK NAME	WF	PROV. SIGNAL	MAN-CHINE	UAL
UNIT WORK 39	40	No 13		
NAME 15				
UNIT WORK 302	131	No 18		
NAME 21				
UNIT WORK 120	20	No 20		
NAME 21				
UNIT WORK 310	65	No 21		
NAME 21				
TOTAL 6238 (RU) PF 95.2%				

WORK NAME	WF	PROV. SIGNAL	MAN-CHINE	UAL
UNIT WORK 146	71	No 22		
NAME 22				
UNIT WORK 106	26	No 23		
NAME 23				
UNIT WORK 61	0	No 24		
NAME 24				
UNIT WORK 51	10	No 25		
NAME 25				
TOTAL 486 (RU) PF 73.6%				

PARALLEL STATIONS

1 2 3 4 5

to tp+1.05 tp+0.85

G STANDARD NO. WORK NAME

WF MEANS MA-CHINE MANHOURL

COMPOSITION MODE: PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY 96.43%

NET COMPOSITION EFFICIENCY